

**Work Order ID 105379****\*105379\***

Page 1

August-01-13 11:24:49 AM

Item ID: D3262-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Cap

Start Date: 8/01/13 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 8/01/13 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 13-08-07

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
<b>*100*</b> Bandsaw	BAND SAW		DAS						
Jeaspa Bandsaw	Memo	0.00	40						
	Cut blanks: 6.000" x 0.500" x 5.400" long Bar	9-83							
	Machine as per Folio FA457 and Dwg D3262								
	Identify for D3262-3								
	Deburr								
110		0.00							
<b>*110*</b> HAAS 1	HAAS CNC VERTICAL MACHINING #1								
HAAS CNC vertical machine #1	Memo	0.00							
	Machine as per dwg D3262								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b> QC	Memo	0.00							
Quality Control									

DAS  
40  
9-83

13/08/16

6 p

13/08/17

6 p

13/08/17

6 p

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>								
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>								
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>								
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector						
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio				<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled			
														<input type="checkbox"/> Other	

Work Order ID 105379

\*105379\*

Page 2

August-01-13 11:24:49 AM

Item ID: D3262-3

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Cap

Start Date: 8/01/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 8/01/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Quality Control

6 SLB-8-19

140

Identify as per dwg & Stock Location: U29663 0.00

\*140\*

Packaging

Packaging

Memo

0.00

(ex SP 13-8-19)

150

QC21- Final Inspection - Work Order Release

0.00

\*150\*

QC

Quality Control

Memo

0.00

13/8/20 JJ

MLJ 13-08-19

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS						
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Work Order Update <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
				Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved												
<b>FAULT CATEGORY</b>												
Landing Gear			General									
			Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced					
			Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure					
			Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld					
			Crushed/Crimped <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled					
			Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>						
			Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>						
			Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>						
			Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>	<input type="checkbox"/> Other						
			Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
			Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							
			Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>							

# Picklist Print

Page 1

August-01-13 11:24:49 AM

Work Order ID: 105379

Parent Item: D3262-3

Parent Item Name: Cap

Start Date: 8/01/13

Required Date: 8/01/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C05.03.10 Removed P/O for liquid penetrant  
inspection KJ/JLM  
571 DD 10.05.10 verified :EC

IPP Rev:D as per ECN10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.000 6061-T6 Bar .500 x 6.00		Purchased	No			100	f	24.8193	0.45	2.8421052	DAS 40 9-89	13/02/16	

Location	Loc Qty	Loc Code
MAT005	24.8192632	
112567	0.8192632	
→ 122521	24	3.15

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____ Part No. _____ NCR No. _____			<b>DISPOSITION</b> <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update			<b>AGAINST DEPARTMENT/PROCESS</b> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">           Skid-tube  <input type="checkbox"/>            Machining  <input type="checkbox"/>            Thermoforming  <input type="checkbox"/>            Large Fab  <input type="checkbox"/> </div> <div style="text-align: center;">           Crosstube  <input type="checkbox"/>            Small Fab  <input type="checkbox"/>            Finishing  <input type="checkbox"/>            Composite  <input type="checkbox"/> </div> <div style="text-align: center;">           Water Jet  <input type="checkbox"/>            Prod. Eng. Coor.  <input type="checkbox"/>            Rec/Store/Packaging  <input type="checkbox"/>            Supplier  <input type="checkbox"/> </div> <div style="text-align: center;">           Engineering  <input type="checkbox"/>            Quality  <input type="checkbox"/>            Other  <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
<b>FAULT CATEGORY</b>											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled							
				<input type="checkbox"/> Other							

DART AEROSPACE LTD	Work Order:	105379
Description: Cap	Part Number:	D3262-3
Inspection Dwg: D3262	Rev: E	Page 1 of 1

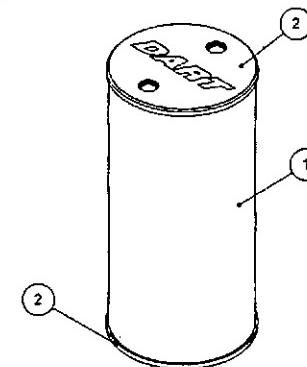
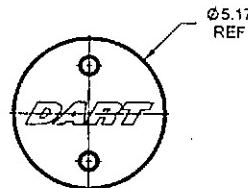
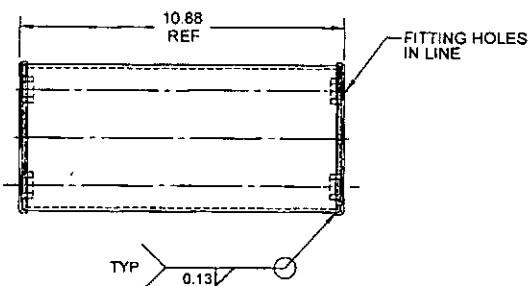
## FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>CMK</u>	Audited by: <u>JL</u>	Preliminary Approval:	N/A
Date: <u>13/08/17</u>	Date: <u>13-8-19</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue P/O D3262-041	KJ/JLM	
B	05.04.28	Dimensions and tolerances revised	KJ/JLM	
C	06.09.27	Dimensions revised per rev. C	KJ/JLM	
D	07.09.06	0.080 was 0.090	KJ/JLM	
E	10.08.03	Dimensions update per Dwg Rev E	KJ	SA



X	VIS. 12-345	CANISTER ASSEMBLY
1	1	SUB. 12-T TUBE
2	2	D3262-3 CAP



105379 MUL

13 08-07

D3262-041 CANISTER ASSEMBLY

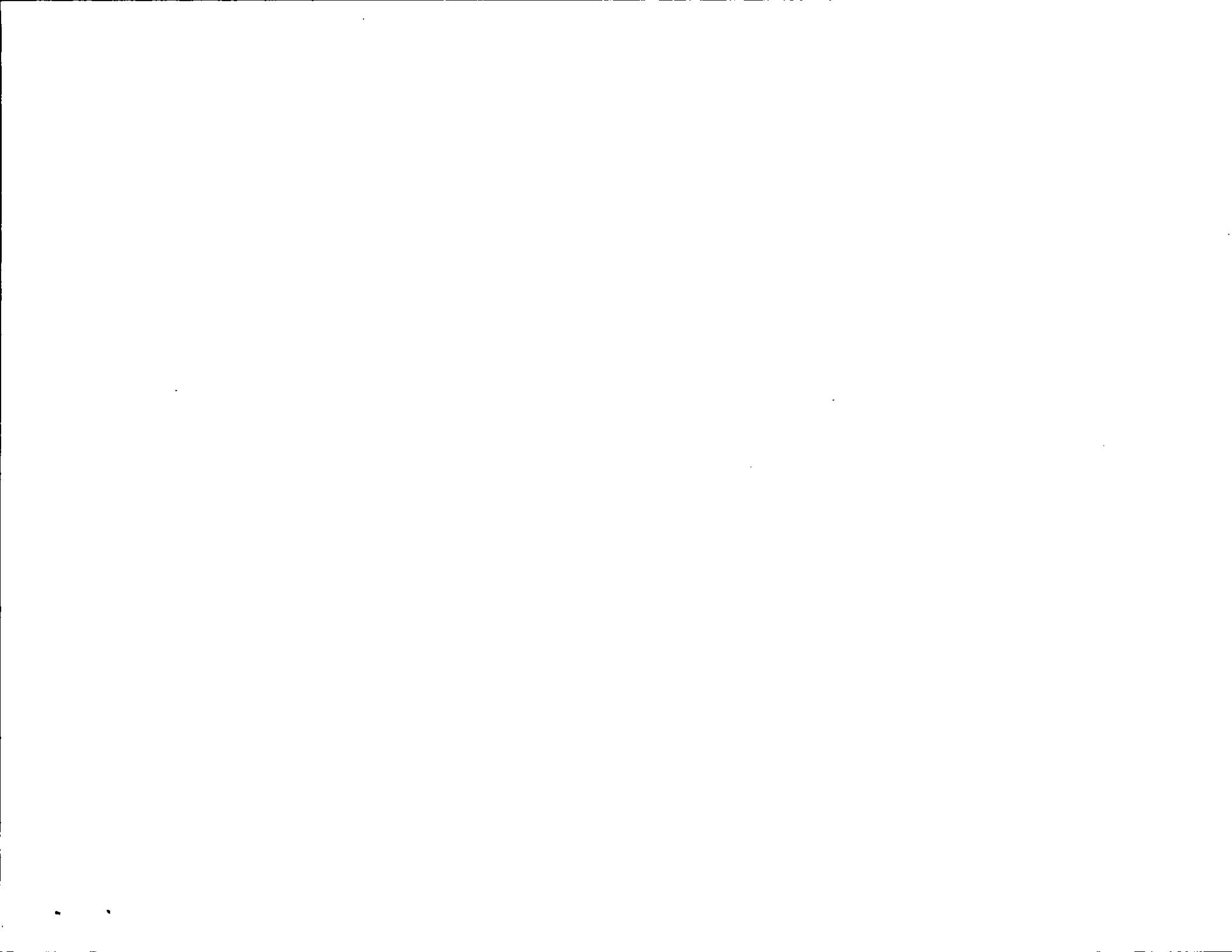
RELEASED  
2010-05-07  
JK

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.51 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR  
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

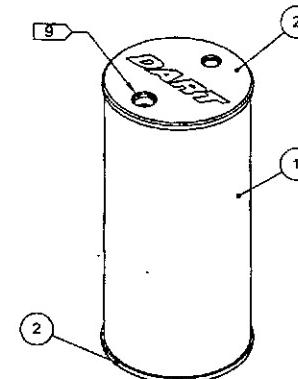
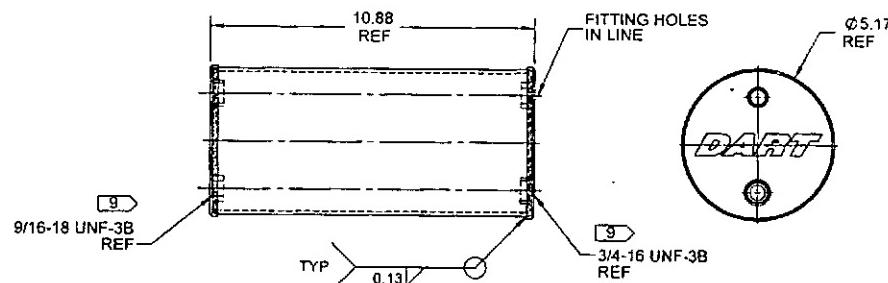
E	0.25 WAS 0.45 (ZN C7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5); ADD DIMENSION (ZN B1-4, D1-5, B1-5)	RF	10.05.03
D	ADD D3262-043-5 (ZN B5-2, B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4, C2-4) PER CAR 09-004	RF	09.12.30
C	Ø5.165 WAS Ø5.190	RF	06.08.31
B	ADD PRESSURE TESTING OPTION	MB	05.02.14
A	NEW ISSUE	RF	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKSLEY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3262	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FUEL PURGE CANISTER	NTS
DATE	10.05.03	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN AUTHORIZATION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



105379

1 1 1  
 2 2 2  
 D3262-5 CAP

D3262-043 CANISTER ASSEMBLY

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.50 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR  
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

RELEASED  
2010-05-07  
M

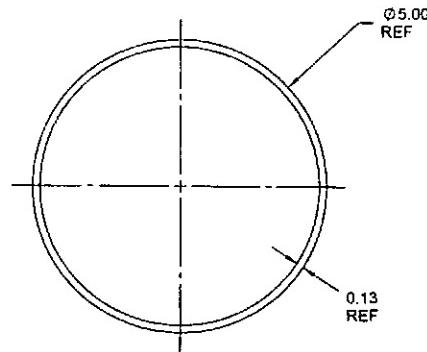
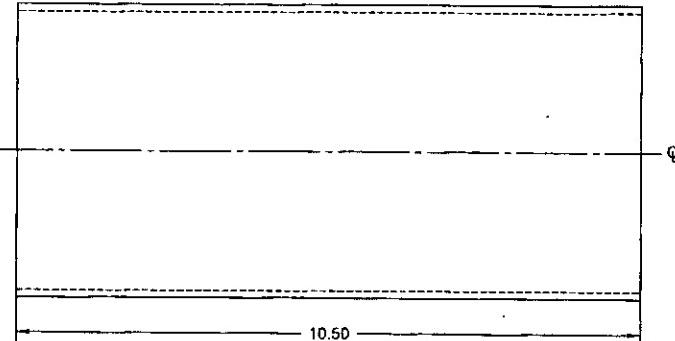
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
		D3262	SHEET 2 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		FUEL PURGE CANISTER	NTS
DE APPR.			
DATE	10.05.03		

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8 7 6 5 4 3 2 1



105379

D3262-1 TUBE

RELEASED  
2010-05-07  
M

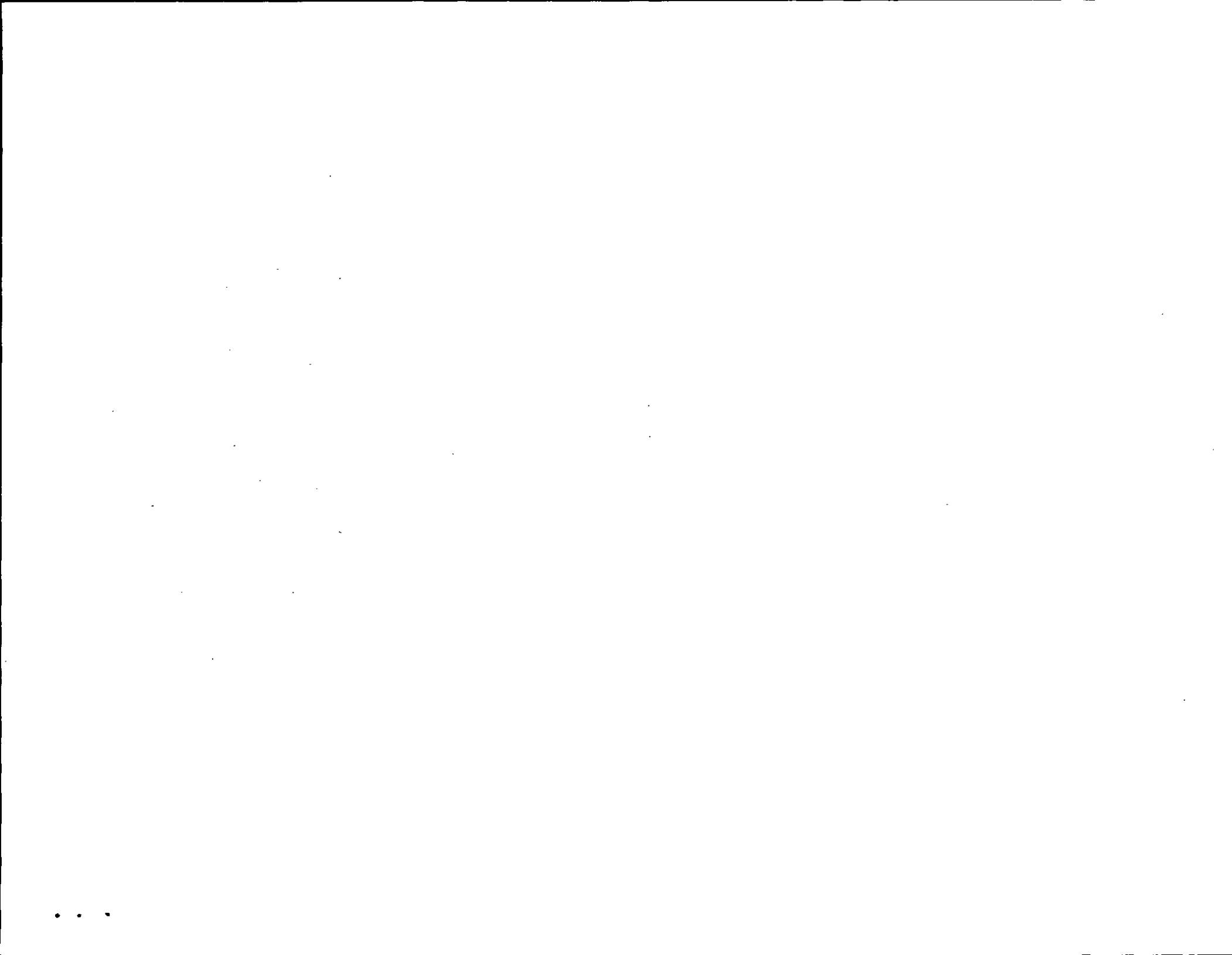
## NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6T5.000W.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.96 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

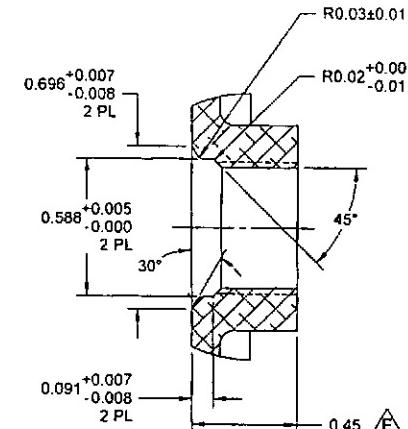
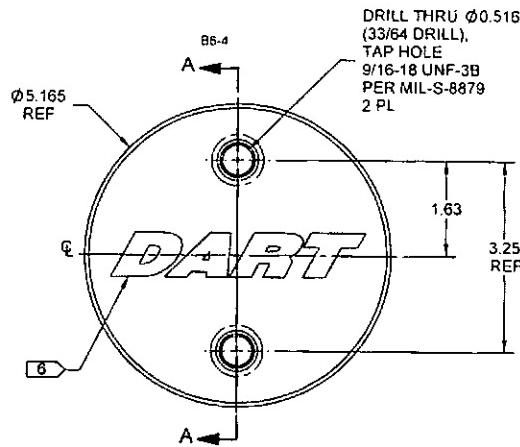
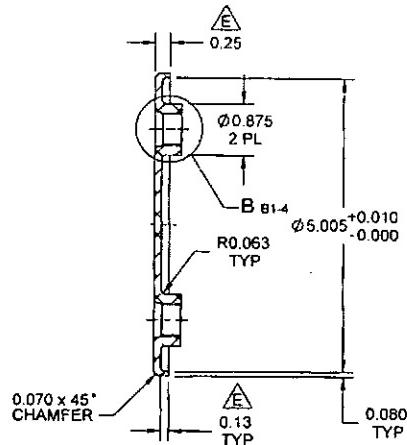
8      7      6      5      4      3      2      1

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED			
MFG. APPR.		DRAWING NO. REV. E	
APPROVED		D3262 SHEET 3 OF 5	
DE APPR.		TITLE	SCALE
DATE	10.05.03	FUEL PURGE CANISTER	NTS

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105378

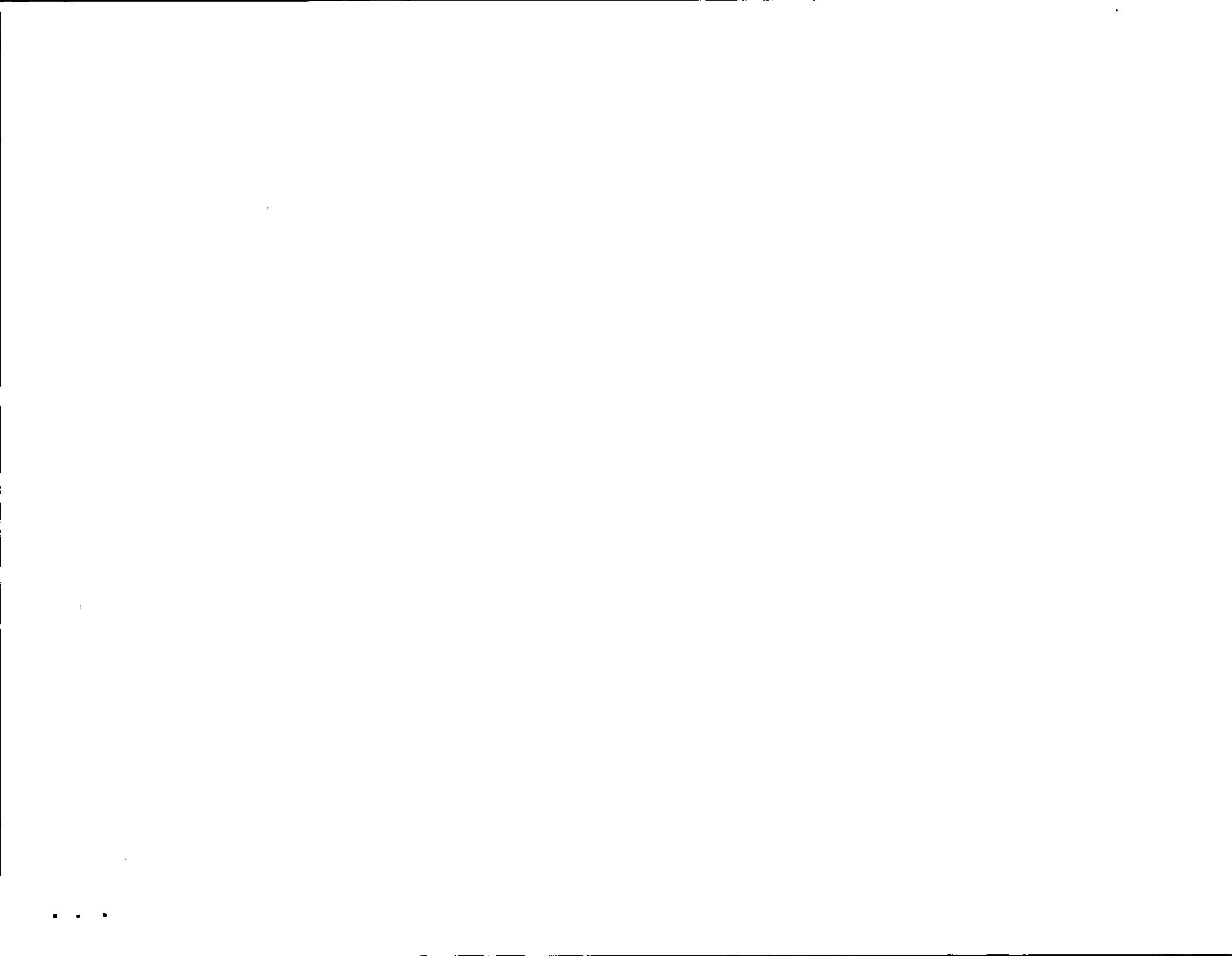


- NOTES:**
- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR  
PER QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6B
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: ENGRAVE 'DART LOGO AS SHOWN USING 0.75 HIGH X 0.010 DEEP  
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
  - 7) WEIGHT: 0.28 lbs
  - 8) PART IS SYMMETRICAL ABOUT CENTERLINE

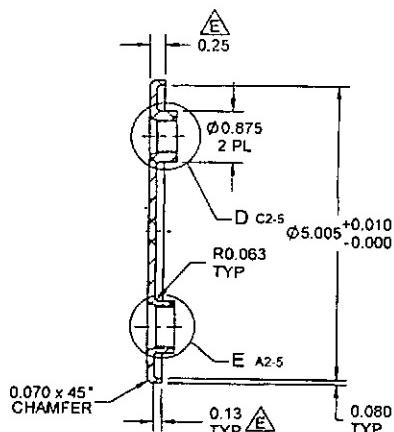
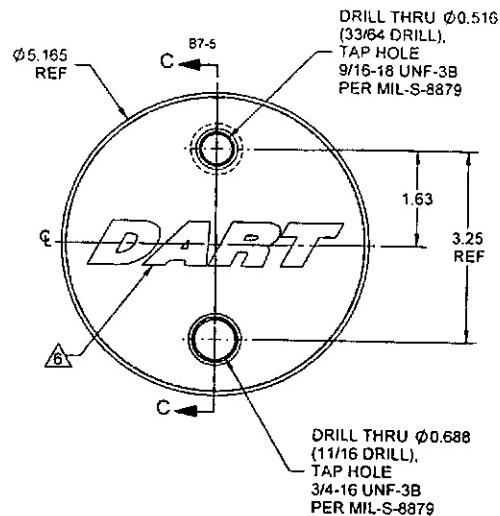
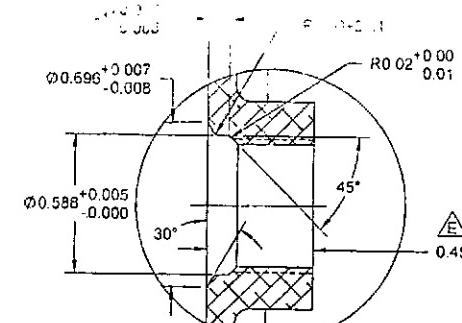
DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	BS	REV. E
MFG. APPR.	SM	DRAWING NO. D3262
APPROVED	MM	SHEET 4 OF 5
DE APPR.	MM	TITLE FUEL PURGE CANISTER
DATE	10.05.03	SCALE NTS

RELEASED  
2010-05-07  
MM

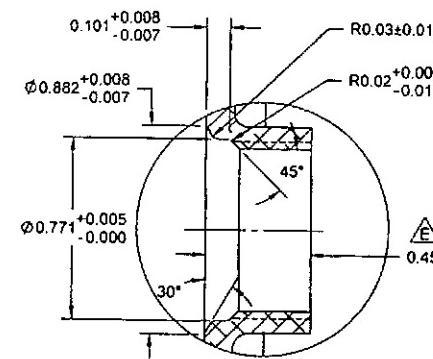
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105379

SECTION C-C D5-5D3262-5 CAP

DETAIL D C7-5

DETAIL E B7-5  
SCALE 2XRELEASED  
2010-05-07  
MM

## NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR  
PER QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M8061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH X 0.010 DEEP  
(MAX LETTERS WITH TOOL RADIUS OF 0.25 MIN)
- 7) WEIGHT: 0.27 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

8 7 6 5 4 3 2 1

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. E	
APPROVED		D3262	
DE APPR.		SHEET 5 OF 5	
DATE	10.05.03	TITLE FUEL PURGE CANISTER NTS	

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